

Work Order ID 68129 - 2

Wednesday, April 06, 2011 4:13:50 PM



Page 1

Item ID: D4269-5

Revision ID: PRELIM

Item Name: Angle

Start Date: 4/7/2011 Start Qty: 2.00

Required Date: 4/8/2011 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



**PRELIMINARY ISSUE**

Cust Item ID:

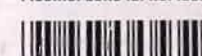
Customer:

Ship Friday  
Apr. 8th

Run Start



Stop



Approvals:

Process Plan:

Date: 11-04-06 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4269

PA1

A

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Cut to length as per dwg  
2- Drill two holes to make R0.25 @ 2 place as per dwg (use 1/2 unibite)  
3- Trace and cut angle as per dwg  
4- Deburr

(2x)

M-1 11/04/07

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

-inspector to PA2  
Dun.  
8/10/07

(+2)

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 BR 11-4-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 68129

Wednesday, April 06, 2011 4:13:50 PM



Page 2

Item ID: D4269-5

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Angle

Start Date: 4/7/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/4/08 (20) \$

140

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

11/4/08 sf 2x

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL  
EFFECTIVE 11/04/08 AUTH h  
RELEASED 5 DATE 11/04/08

Reinspects to Next Day

CMF  
11-04-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, April 06, 2011 4:13:47 PM

Page 1

Work Order ID: 68129



Parent Item: D4269-5



Parent Item Name: Angle

Start Date: 4/7/2011

Required Date: 4/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.04.04 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3A.750X.750X. 063W		Purchased	No			100	f	33.0000	1.9375	4.078947			
Angle2024T3511 .750 x .750 x .063w													

## Location

MAT028

103509

116909

## Loc Qty

33

24

9

## Loc Code

M-1 11/04/07  
~~1.9375~~  
~~4.078947~~  
 4.078947

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

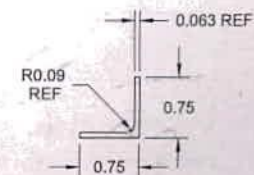
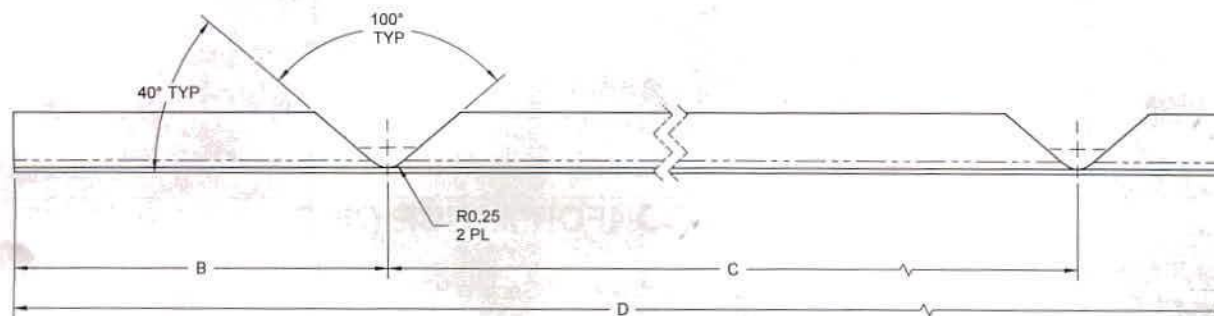
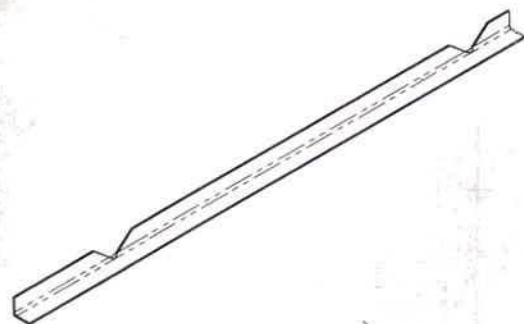
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D4269-Z**  
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-Y)

PART NUMBER	DESCRIPTION	EA20469-Y	B	C	D
D4269-5	ANGLE	EA20469-29	4.66	16.69	23.25
D4169-7	ANGLE	EA20469-32	2.28	16.5	22.03

# 68129

**PRELIMINARY ISSUE**

10.11.22

**NOTES:**

- 1) MATERIAL: 2024-T4/T3510/T3511 ALUMINUM ANGLE  
PER QQ-A-200/3  
PER DART SPEC. M2024T3511A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4269</b>	REV. PA SHEET 2 OF 2
MFG. APPR.		TITLE <b>VRD PARTS</b>	SCALE NTS
APPROVED		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DE APPR.		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	
DATE	10.11.22		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





105.53

105.53

105.53

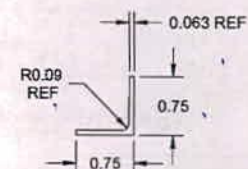
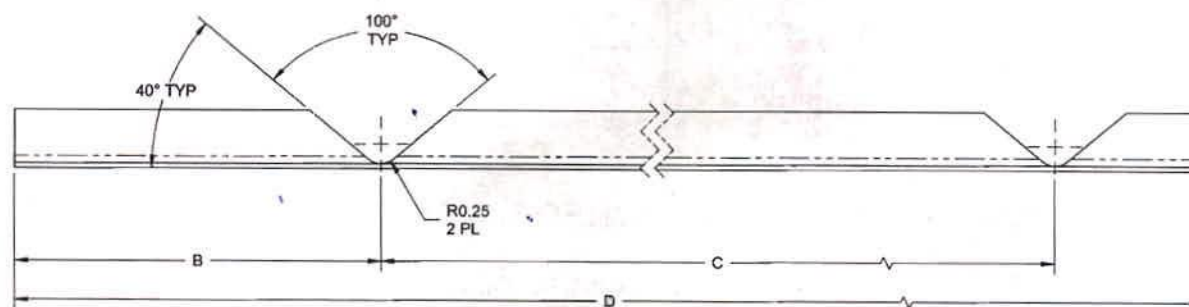
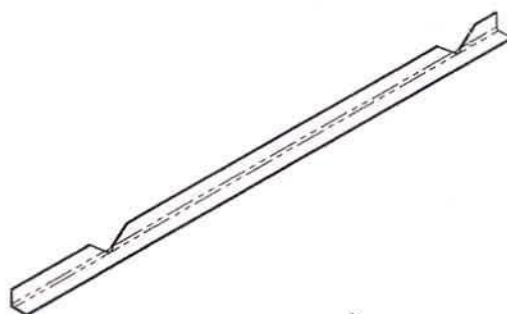
105.53

105.53

105.53

105.53





**D4269-Z**  
(REF. EAGLE DRAWING NO. D2046902 P/N EA20469-Y)

PART NUMBER	DESCRIPTION	EA20469-Y	B	C	D	WEIGHT
D4269-5	ANGLE	EA20469-29	4.66	16.69	23.25	0.21
D4269-7	ANGLE	EA20469-32	2.28	16.5	22.03	0.19

**NOTES:**

- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE  
PER QQ-A-200/3  
OR AMS 4152, 4164 & 4165  
PER DART SPEC. M2024T3AH0.75XW0.75XT0.063R0.090
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: SEE TABLE

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4269</b>	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>VRD PARTS</b>	NTS
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
R 2011-04-08

68129

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries